

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003825**Date Inspected:** 04-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed ultrasonic testing (UT) at the completed joint penetration at floor beam joints SSD9A-PP047-133, SSD15-PP047-133, FB-015-020-026, FB-010-011-026, FB-016-021-026, FB-009-013-026, FB-015-021-026, FB-009-015-026, FB-010-014-026 and FB-009-014-026. The QA inspector performed 10 % UT at random location. The QA inspector found that welds areas tested appeared to be in compliance with the contract documents. See UT report TL_6027 generated on this date.

The QA inspector was in the Tower Assembly area to perform ultrasonic testing (UT) at the junction of longitudinal stiffeners to skin plate As (South and East shaft). The QA inspector observed that no areas were marked as acceptable and the areas that were rejected, were not clearly identified. After the QA inspector had a conversation with ZPMC representatives and Caltrans representative Larry Viars. The QA inspector found that ZPMC did not notified Caltrans of the testing because ZPMC's UT was intended to be a preliminary for informational purpose only. After numerous rejectable indications were found, ZPMC on their on risk decided to precede performing numerous weld repairs without informing Caltrans and without performing a formal UT test required per contract documents.

Summary of Conversations:

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As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua T. Ishibashi, 086-13764710411., who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	Lanz,Joe	QA Reviewer
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